

Date: Monday, 10/16/2006 1:56:29 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW  
 Job Number : 28995  
 Estimate Number : 10262  
 P.O. Number : N/A Part Number : D350636011  
 This Issue : 10/16/2006 S.O. No. : N/A Drawing Number : D2750  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 28966 Material : N/A  
 Due Date : 11/10/2006 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: 02-09-25 Rearranged procedure steps KJ  
 Est Rev:J 06-03-23 As per Rev D JLM  
 Est Rev:J 06-07-13 As per dsi9343 EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 002

KT 06-10-17 (1)

2.0

D26003BENT

Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D2600-3-Bent

Extrusion (Bent)

626787

~~626787~~

KT 06-12-12

3.0

D2744

Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

3 27539 BE 06-12-12

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 &amp; DT8863 drilling holes labelled "A" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut as per dwg D2750

KT 06-12-12

KT 06-12-12

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |  |    |      |                  |                                     |                          |
|------|------|--------------------|--|----|------|------------------|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty <sup>o</sup> | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |                  |                                     |                          |
|      |      |                    |  |    |      |                  |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B      | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 28995

Part Number: D350636011

Job Number:



Seq: #

Machine Or Operation:

Description:

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" \*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Grind welds flush as per Dwg D2750

BE 06-12-12

9-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750

10-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod

M101446 BE 06-12-12

11-Countersink Detail A as per dwg D2750.

BE 06-12-12

12- Scribe batch# inside per dwg D2750

BT 06-12-12

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/12/18 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-12-18 (1)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SR/PM 06-12-18 (1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BT 06-12-18

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                      |                                 |                |                           |                       |                          |
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 28995

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

29316 PM JB 06-12-19-①

10.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B28874 BE 06-12-20

11.0

D34903

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B29016 BE 06-12-20

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

B2774V BE 06-12-20

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

PM 06-12-18①

2-Open up holes of Detail D to 0.750" (total of 4 holes per side) as per dwg D2750.

PM 06-12-18①

3-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

PM 06-12-18①

4-Deburr and blow out all chips from inside of tube

PM 06-12-18①

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

M 102672

exp. date:

07-01-01 JS / JB 06-12-19 ①

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
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|      |      |                    |  |    |      |     |                                     |                          |  |
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                      |                                 |                |  |                           |                       |                          |
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|      |      |                                  |                      |                                 |                |  |                           |                       |                          |

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 28995

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description:

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 4)

A/R Aluminum Rod batch: *M101446 BE 06-12-20*

8-Grind welds flush as per Dwg D2750 *Pm 06-12-21 ①*

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 *Pm 06-12-21 ①*

10-Deburr holes *Pm 06-12-21 ①*

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*06/12/21 ①*

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06/12/21 ①*

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*07/18*

*07-01-15 ①*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*07/18 ①*

18.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

INSERT

Batch: *M103183*

*07/18*

*07-01-18*

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

*07/18*

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 28995

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Inspect Inserts

FC 07 01 18 ①

21.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Wearpad  
Batch: B29038

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearplate  
Batch: B27739

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearplate  
Batch: B26206

24.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearplate  
Batch: B29012

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing  
Batch: B28974

26.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Blade Fitting, LH  
Batch: B28318

JS/YL 07-0118

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |                |  |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B      |  | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign &<br>Date |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 28995

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

27.0 D3492041 PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
PLUG ASSEMBLY  
Batch: 1329363

28.0 D3492043 PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
PLUG ASSEMBLY  
Batch: 1329364

29.0 AN3C5A Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)  
Bolt  
Batch: M102985

30.0 AN3C6A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt  
Batch: 319522

31.0 AN3C7A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BOLT  
Batch: M102254

32.0 AN6C44A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BOLT  
Batch: M102410

33.0 AN8C35A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BOLT  
Batch: M102180

*Handwritten signature/initials*

07-01-08

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 28995

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

washer

Batch: M 102079

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M 100186

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: 102332

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M 100186

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

WASHER

Batch: M 101542

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

WASHER

Batch: M 102535

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch:

M 101915

2/14/07 07-01-05

2/14/07 07/01/19

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 28995

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description:

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 102672

EXP DATE: 02/07

*Handwritten:* 11/19  
02/01/19

4-Coat all exposed fasteners with "LPS Procyon" batch: M17168

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 10/20/06 @

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade

Batch: AB 28521

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M100186

45.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M100186

46.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M102735

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: HP Date: 07/10/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |                |                           |                       |                          |
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|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Monday, 10/16/2006 1:56:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW

Job Number: 28995

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M1-2515 ✓

48.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B2-7835 ✓

49.0

D35321

spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: B27897 ✓

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

52.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-01-25

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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06-02-07

|                        |                         |   |                        |
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| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D2750  | REV. D<br>SHEET 1 OF 5 |
| DATE<br>06.01.05       |                         | TITLE<br>350 SKIDTUBE ASSEMBLY<br>SCALE<br>NTS                          |                        |
| A                      | 98.04.16                | NEW ISSUE   |                        |
| B                      | 98.09.01                | CHANGE MS24694-S293 TO AN8-16A  |                        |
| C                      | 98.11.18                | ADD D2750-3/D2750-4<br>INCORPORATE D2738 AND D2740                      |                        |
| D                      | 06.01.05                | ADD HOLES AND SPACERS FOR<br>APICAL FLOATS<br>INCORPORATE DEO 9133/9157 |                        |

| Qty<br>-041 | Qty<br>-042 | Qty<br>-043 | Qty<br>-044 | Part Number    | Description           |
|-------------|-------------|-------------|-------------|----------------|-----------------------|
| X           |             |             |             | D2750-041      | SKIDTUBE ASSEMBLY, LH |
|             | X           |             |             | D2750-042      | SKIDTUBE ASSEMBLY, RH |
|             |             | X           |             | D2750-043      | SKIDTUBE ASSEMBLY, LH |
|             |             |             | X           | D2750-044      | SKIDTUBE ASSEMBLY, RH |
| 5           | 5           | 5           | 5           | D2648-3        | WEARPAD               |
| 1           | 1           | 1           | 1           | D2656-13       | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2656-35       | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2746          | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2739          | WEB                   |
| 1           | 1           | 1           | 1           | D2741          | BLADE                 |
| 8           | 8           | 8           | 8           | D2743          | SPACER                |
| 1           | 1           | 1           | 1           | D2744          | CAP                   |
| 8           | 8           | 8           | 8           | D2745          | BUSHING               |
| 1           |             |             |             | D2750-1        | SKIDTUBE WELDMENT, LH |
|             | 1           |             |             | D2750-2        | SKIDTUBE WELDMENT, RH |
|             |             | 1           |             | D2750-3        | SKIDTUBE WELDMENT, LH |
|             |             |             | 1           | D2750-4        | SKIDTUBE WELDMENT, RH |
| 1           |             | 1           |             | D3488-041      | BLADE FITTING, LH     |
|             | 1           |             | 1           | D3488-042      | BLADE FITTING, RH     |
| 4           | 4           | 4           | 4           | D3490-1        | SPACER                |
| 4           | 4           |             |             | D3490-3        | SPACER                |
|             |             | 4           | 4           | D3490-5        | SPACER                |
| 8           | 8           | 8           | 8           | D3492-041      | PLUG ASSEMBLY         |
| 8           | 8           |             |             | D3492-043      | PLUG ASSEMBLY         |
|             |             | 8           | 8           | D3492-045      | PLUG ASSEMBLY         |
| 38          | 38          | 38          | 38          | AN3C5A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN3C6A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN3C7A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN6C44A        | BOLT                  |
| 2           | 2           | 2           | 2           | AN8C21A        | BOLT                  |
| 1           | 1           | 1           | 1           | AN8C35A        | BOLT                  |
| 46          | 46          | 46          | 46          | AN960C10L      | WASHER                |
| 4           | 4           | 4           | 4           | AN960C816L     | WASHER                |
| 4           | 4           | 4           | 4           | MS21043-6      | NUT                   |
| 3           | 3           | 3           | 3           | MS21083C8      | NUT                   |
| 42          | 42          | 42          | 42          | NAS1330S3KB166 | INSERT                |
| 46          | 46          | 46          | 46          | NAS1515H3L     | WASHER                |
| 12          | 12          | 12          | 12          | NAS1515H8L     | WASHER                |

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|                  |                |  |                        |
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| CHECKED<br>PH    | APPROVED<br>PH | DRAWING NO.<br>D2750                         | REV. D<br>SHEET 2 OF 5 |
| DATE<br>06.01.05 |                | TITLE<br>350 SKIDTUBE ASSEMBLY               | SCALE<br>NTS           |

RELEASED  
06-02-07

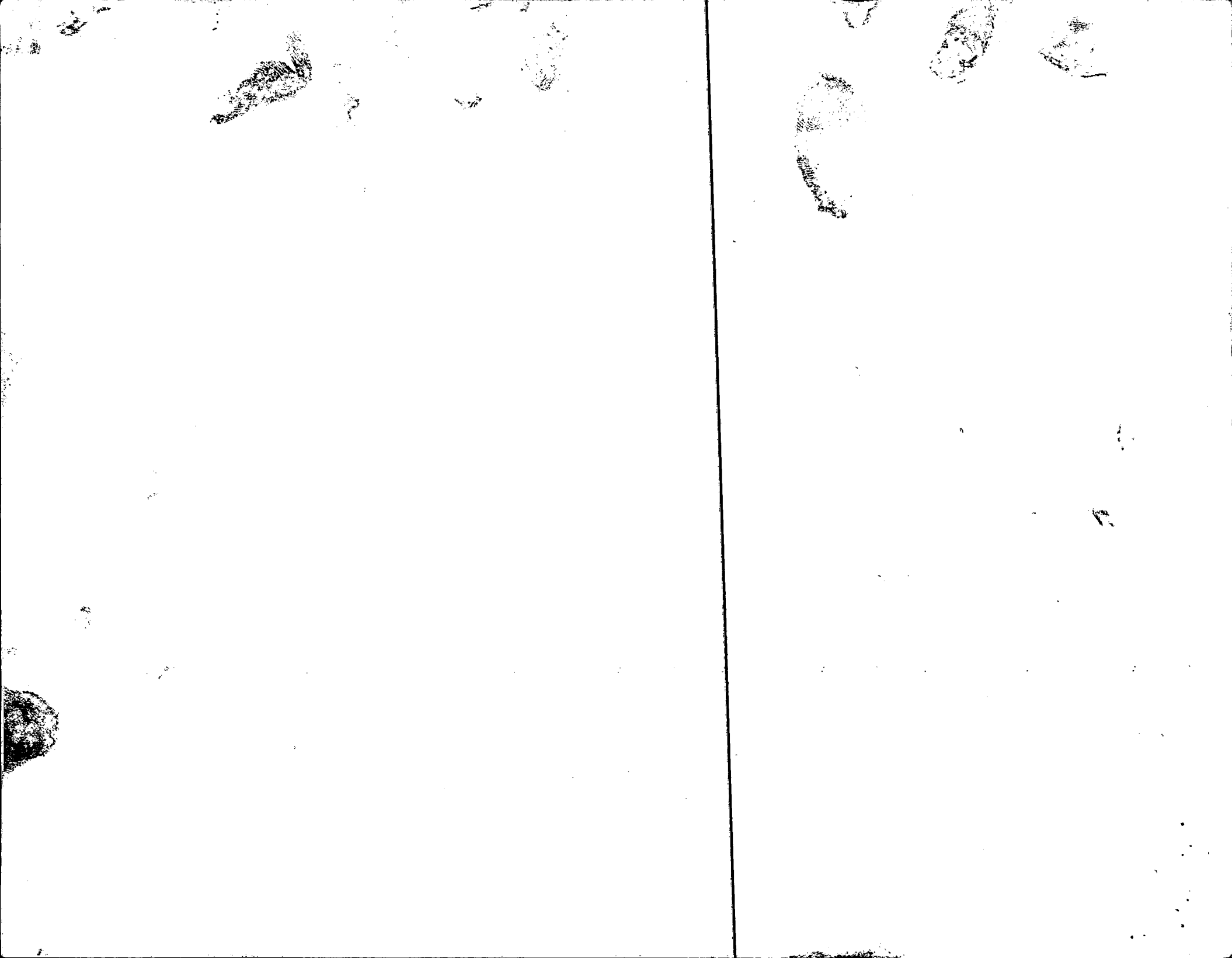
GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ( $\emptyset 0.250$ -  $\emptyset 0.257$ ) FOR WEARSHOE INSERTS. C'SINK  $\emptyset 0.391 \times 100^\circ$  AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

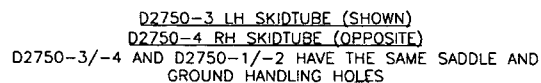
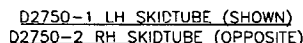
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02.02.07 #



WORK ORDER  
NO. 28995

(FROM WEARSHOE CL  
TO SKIDTUBE CL.)  
0.110


17"

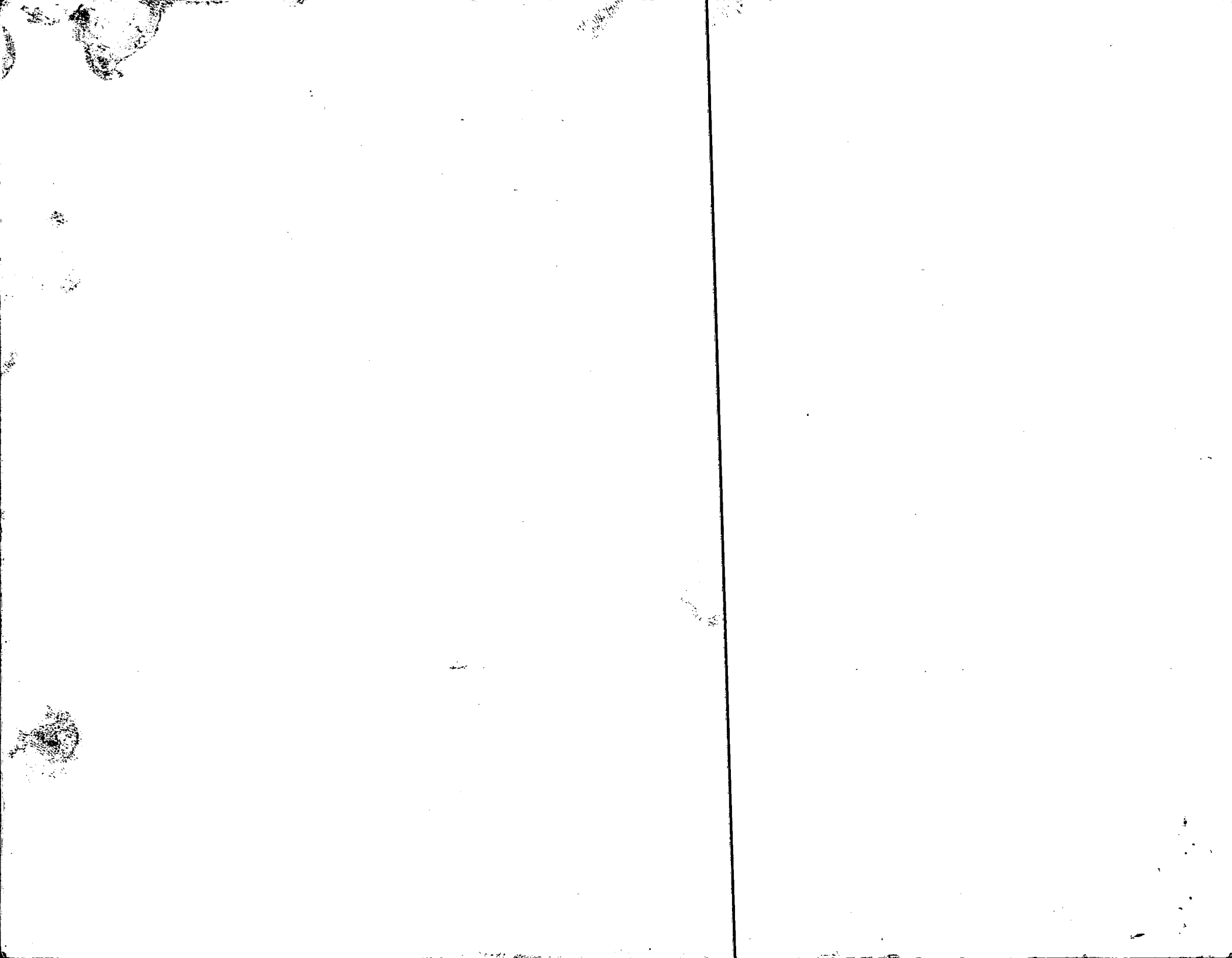
SECTION E-E

49°  
(REF)

41°  
(REF)

SECTION F-F

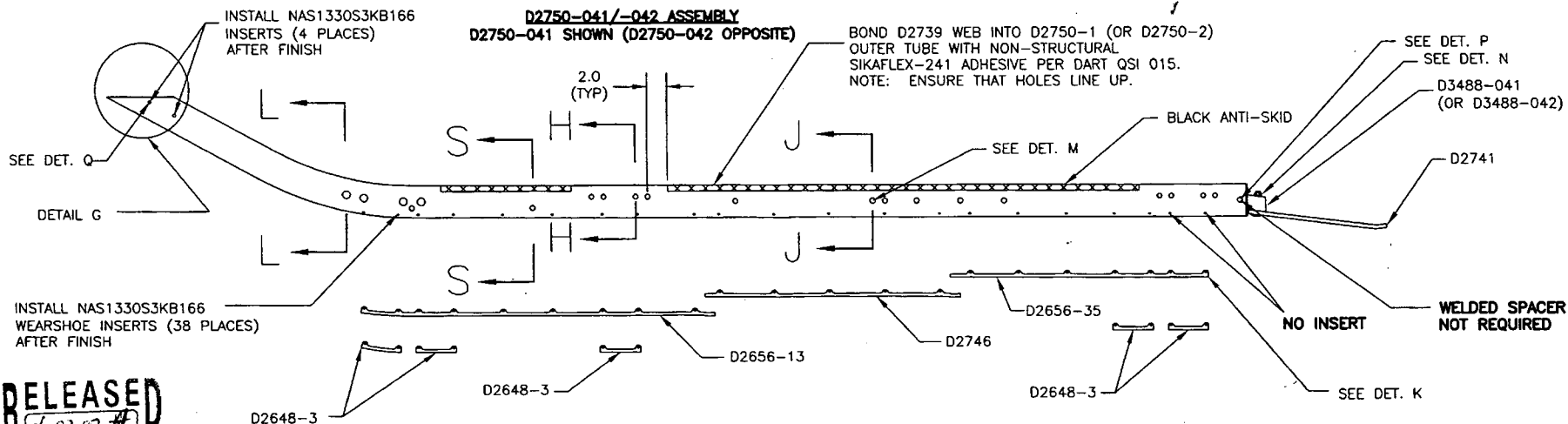
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| DATE<br>06.01.05   |  | TITLE<br>350 SKIDTUBE ASSEMBLY<br>SCALE<br>1:20 |                |   |                        |



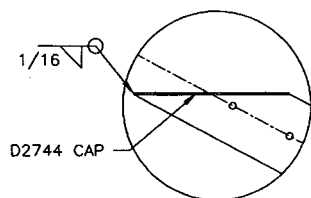
RELEASED  
06.02.07

**D2750-041/-042 ASSEMBLY**  
D2750-041 SHOWN (D2750-042 OPPOSITE)

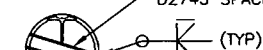
BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.



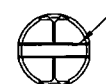
DETAIL G



SECTION H-H



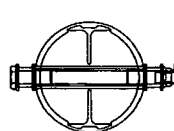
SECTION J-J



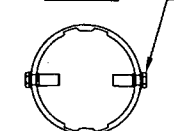
**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



DETAIL Q



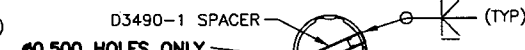
SECTION L-L



Ø0.750 HOLES ONLY

D3492-043 PLUG ASSEMBLY

SECTION S-S



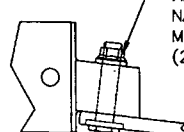
Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

DETAIL N

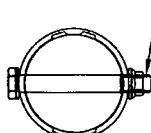


DETAIL K



AN3C5A BOLT (1)  
AN960JD10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

DETAIL P



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TITLE  
350 SKIDTUBE ASSEMBLY

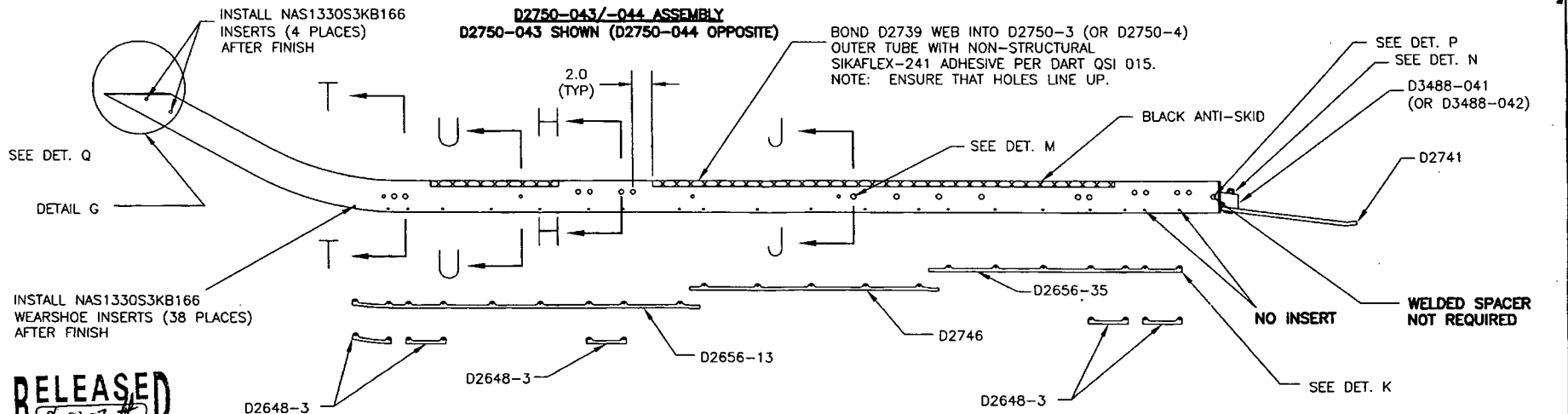
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SHEET 4 OF 5  
SCALE  
1:20

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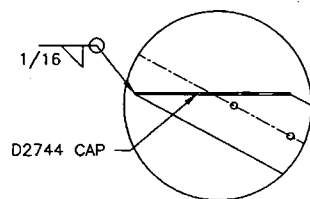


**D2750-043/-044 ASSEMBLY**  
**D2750-043 SHOWN (D2750-044 OPPOSITE)**

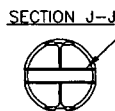
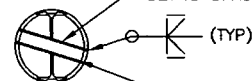


**RELEASED**  
 06-02-07-14

**DETAIL G**



**SECTION H-H** D2743 SPACER (REF)



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2743 SPACER
  3. WELD INTO PLACE
  4. GRIND FLUSH
  5. DRILL OUT SPACER TO Ø0.484
  6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

**SECTION T-T**



Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

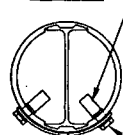
**SECTION U-U**



Ø0.313 HOLES ONLY

D3492-045 PLUG ASSEMBLY

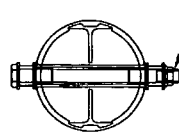
**DETAIL K**



USE AN3C7A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD (4 PLACES)

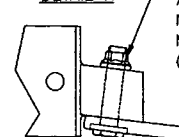
AN3C5A BOLT (1)  
 AN960C10L WASHER (1)  
 NAS1515H3L WASHER (1)  
 (38 PLACES)

**DETAIL M**



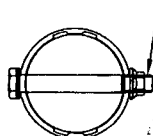
AN6C44A BOLT (1)  
 D2745 BUSHING (2)  
 NAS1515H8L WASHER (2)  
 MS21043-6 NUT (1)  
 (4 PLACES)  
**NOTE: INSTALL WASHER BETWEEN SKIDTUBE AND BUSHING**

**DETAIL N**



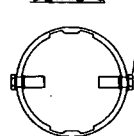
AN8C21A BOLT (1)  
 AN960JD816L WASHER (1)  
 NAS1515H8L WASHER (1)  
 MS21083C8 NUT (1)  
 (2 PLACES)

**DETAIL P**



AN8C35A BOLT (1)  
 AN960C816L WASHER (2)  
 NAS1515H8L WASHER (2)  
 MS21083C8 NUT (1)

**DETAIL Q**



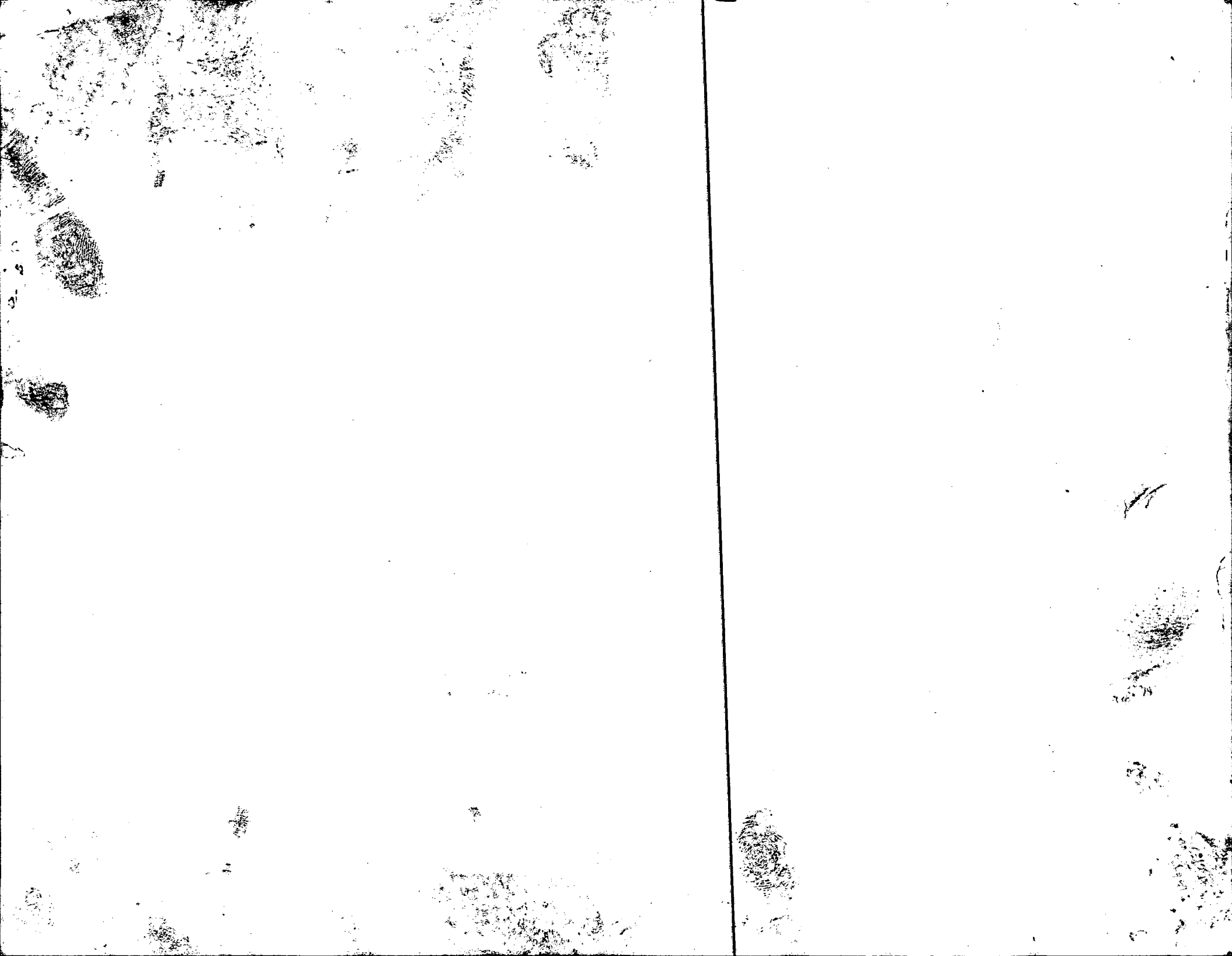
AN3C6A BOLT (1)  
 AN960C10L WASHER (1)  
 NAS1515H3L WASHER (4 PLACES)

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| CHECKED | #        | APPROVED | #                     | DRAWING NO.<br>D2750                                     | SHEET 5 OF 5 |
| DATE    | 06.01.05 | TITLE    | 350 SKIDTUBE ASSEMBLY | SCALE  | 1:20         |



NO. 82

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number A350 636 011/B29428

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

|              | Position                    | Vertical                               | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|--|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input checked="" type="checkbox"/> | 3G <input type="checkbox"/>   | 4G <input type="checkbox"/> |
| Tube Groove  | 1G <input type="checkbox"/> | 2G <input checked="" type="checkbox"/> | 5G <input type="checkbox"/>   | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input checked="" type="checkbox"/> | 3F <input type="checkbox"/>   | 4F <input type="checkbox"/> |
| Tube Fillet  | 1F <input type="checkbox"/> | 2F <input checked="" type="checkbox"/> | 4F <input type="checkbox"/>   | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/12/18 Qualifier David A. Avel